



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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RBWA353A04
Job Sheet 197629



Part No: RBWA353A04

Job Qty: 4 pcs

Part Name: Pmc Oil Filling Quick Disconnect



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/11/19

Job Tracking No:

Due Date: 8/9/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG RBWA353A04 Rev 4 IPP Rev A 18.02.13 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	4 pcs	8/9/19	8/9/19	0.00	4.00	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	4 pcs	8/9/19	8/9/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		DAS AUG 22 2019 40 9-89
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	4 pcs	8/9/19	8/9/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		



Container No: S208224



Part: RBWA353A04

Job No: 197629

Serial No/Batch: S208224

Revision: 4

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/22/19

				Packaging 3 - 6 - B4B	DAS
				Packaging 3 - 7 - B4B	28
				Packaging 3 - 8 - B4B	9-89
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - SA	4 pcs	8/9/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

AUG 23 2019

DAS
70
9-89DAS
77
9-89

Part Op 110 - Small Fab - 1-Assemble as per DWG. Sheet . 2-Engrave 1632T22 tag using marktronic engraver as per DWG. 3-Descriptions: Fabricate and attach lanyard as per DWG.

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

GA
137

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
1632T22	Aluminum Tag 1" X 2" X 0.04"	4 pcs (1 ea)	110-Small Fab - 1	5200927
2619	Spring Rnd 3/4"	4 Ea (1 ea)	110-Small Fab - 1	5075095
3896T31	Ferule 1/16 X 3/8" - Aluminum	8 Ea (2 ea)	110-Small Fab - 1	5206750
50715K179	Female Pipe Adapter SS	4 Ea (1 ea)	110-Small Fab - 1	5206441
91665A350	Retaining Ring, 7/16" Shaft	4 Ea (1 ea)	110-Small Fab - 1	5096069
9262K613	O-Ring 13mm OD x 1mm	4 Ea (1 ea)	110-Small Fab - 1	5046049
CL-2-C	Lanyard Wire	1.6800 ft (.42 ea)	110-Small Fab - 1	5190004
RBWA353A04-01	Cap	4 pcs (1 ea)	110-Small Fab - 1	5155897
RBWA353A04-02	Sleeve	4 pcs (1 ea)	110-Small Fab - 1	5146133
RBWA353A04-03	Barb	4 pcs (1 ea)	110-Small Fab - 1	5140141
RBWA353A04-05	Quill	4 pcs (1 ea)	110-Small Fab - 1	5136861
RBWA353A04-06	Cap	4 pcs (1 ea)	110-Small Fab - 1	5154887
RBWA353A04-07	Valve	4 pcs (1 ea)	110-Small Fab - 1	5137129
RBWA353A04-08	Screw (Modified B/O)	8 pcs (2 ea)	110-Small Fab - 1	5201594 4X50
S1030	Spring .025 Wire: .300 O.D X .5 free length	4 Ea (1 ea)	110-Small Fab - 1	5157801

4+1

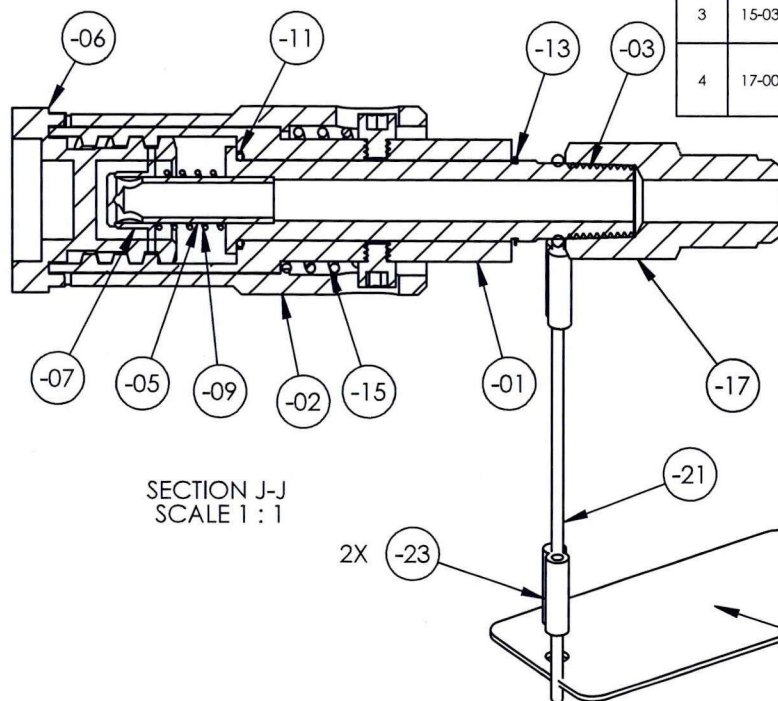
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Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	1632T22	4	52	0
	2619	4	27	0
	3896T31	8	503	0
	50715K179	4	2	0
	91665A350	4	6	0
	9262K613	4	78	0
	CL-2-C	2	1,234	0
	RBWA353A04-01	4	5	0
	RBWA353A04-02	4	5	0
	RBWA353A04-03	4	7	0
	RBWA353A04-05	4	6	0
	RBWA353A04-06	4	5	0
	RBWA353A04-07	4	6	0
	RBWA353A04-08	8	5	0
	S1030	4	10	0
Part Specifications				
Specifications could not be found.				

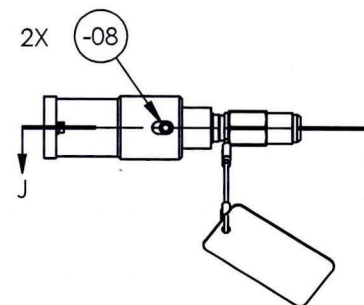
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		REDESIGNED ASSEMBLY	2/22/2011	JAG	
2		DELETED -19, -21, & -23 CH'D -15 FROM HOSE & -17 FROM HOSE CLAMP, ADDED -19, -21, & -23. -01 CH'D TO CLEAR ANODIZE, -02 CH'D TO CLEAR ANODIZE, CH'D -03 THRU HOLE FROM Ø.17, CH'D DESIGN ADDED 1/8 NPT -27 FOR FITTING, CH'D -05 ID FROM Ø.14 & CH'D LIMIT DIMENSION FROM Ø.2510-.2514 S.F. -07, CH'D -07 ID LIMIT DIM. FROM Ø.2515-.2520 & S.F. -05 PER D.W.	1/17/2012	RJC	DW
2A		-03 REMOVED X.50 DEPTH FROM 1/8 NPT	1/3/2013	BIM	GE
3	15-0335	-01 DIM WAS Ø.675 IS Ø.665 TO ACCOMMODATE NEW -15 SPRING. -02 CH'D DIM'S WAS 2X Ø.800 IS Ø.800, ADDED DIM Ø.810 FOR NEW SPRING, CH'D ENGRAVE NOTE WAS ENGRAVE 1/N TO FIT IS ENGRAVE 1/N, S/N, MADE IN USA. -15 CH'D P/N WAS CENTURY SPRING #B15-66 IS 2619.	10/13/2015	RJC	JAG
4	17-0070	UPDATED TO NEW STANDARDS. -01 CH'D FLANK OF THREAD START WAS ON CENTERLINE, IS 5° OFFSET FROM CENTER LINE, WAS 17° IS (16°); WAS (.10) IS (.08); WAS .101 IS .100. -03 CH'D DIM WAS 2X Ø.438 IS 2X Ø.4374/.4354, -05 CH'D DIM WAS Ø.2515/.2510 S.F. -07 IS Ø.2515/.2510 (S.F. -07). -06 ADDED. -07 CH'D DIM WAS Ø.2530/.2520 S.F. -05 IS Ø.2530/.2520 (S.F. -05).	3/21/2017	SM	JAG



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 197629
ML5
1907-11



B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	-01	1	CAP	6061		2
	-02	1	SLEEVE	6061		3
	-03	1	BARB	303/304 S.S.		4
	-05	1	QUILL	303/304 S.S.		5
	-06	1	CAP	6061		6
	-07	1	VALVE	303/304 S.S.		7
	-08	2	SCREW	S.S.	6-32 X 1/8 (MCMaster-CARR #92196A139) MODIFIED	8
B/O	-09	1	SPRING	MUSIC WIRE	Ø.025 WIRE: Ø.300 OD X .5 FREE LENGH (RIED #S1030)	1
B/O	-11	1	O-RING	BURNA-N	Ø13mm OD X 1mm (MCMaster-CARR #9262K613)	1
B/O	-13	1	EXTERNAL RETAINING RING	SPRING STEEL	Ø7/16 SHAFT (MCMaster-CARR #91665A350)	1
B/O	-15	1	SPRING	SPRING STEEL	Ø.78 (CENTURY SPRING #2619)	1
B/O	-17	1	FEMALE PIPE ADAPTER	S.S.	MCMaster-CARR #50715K179	1
	-19	1	TAG	ALUMINUM	1/32 X 1 X 2	1
B/O	-21	1	LANYARD	COATED GALV. STEEL	(7X7 CABLE) Ø1/16 X 5in. (CARR LANE #CL-2-2)	1
B/O	-23	2	FERRULE	ALUMINUM	Ø1/16 X 3/8 (MCMaster-CARR #3896T31)	1

		TITLE	
		PMC OIL FILLING QUICK DISCONNECT	
DWG NO.		RBWA353A04	
REV		4	
MATERIAL		UNLESS OTHERWISE SPECIFIED	
FINISH		DIMENSIONS ARE IN INCHES	
SPEC		.XXX ± .005 FRACTIONS ± 1/8	
DRAWN BY:		.XX ± .01 ANGLES ± 5°	
CHECKED:		.X ± .1 SURFACES = 125/	
OPPS APPR:		1. BREAK ALL SHARP EDGES	
QA APPR:		.015 x 45° OR .015R	
APPROVED:		2. DIMENSIONAL LIMITS APPLY	
SCALE		AFTER PLATING	
1:3		3. INTERPRET DIM AND TOL PER	
DATE		ASME Y14.5M-2009	
2/22/2011		USED ON MODEL	
SHEET 1 OF 8		AGUSTA HELICOPTERS	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					